POWER DESIGN & CONSTRUCTION DEPARTMENT OF WATER AND POWER CITY OF LOS ANGELES

FILE 16591-3 J. HINTZE -IFF

QUALITY ASSURANCE OFFICE INSPECTION REPORT

ЈОВ	Contract 9010 - IPP Replacement Burners - Unit 1	QA CHARGE NCY54 MEP D-5706 AFE NCY54
CONTRACTOR	Babcock & Wilcox	LOCATION Paris, TX
LEAD ENGINEER	Mr. R. Krikorian	LOCATION GOB
SPO NOS	ITEMS	COVERED Coal Burners
ACTIVITY Fabri	cation Inspection REPORT PERIO	DD 3/01-3/04/92 REPORT 4

SUMMARY

Work Progress and Quality

As of this reporting period, March 2-3, 1992, the progress of burner fabrication and assembly has been good. There have been some deficiencies noted in the quality.

More Significant Items

Deficiencies in the quality of fit-ups and attention to detail in the assembly areas have been noted and brought to the attention of appropriate B&W plant personnel.

Schedule Status

As of this report the work is ahead of schedule.

DETAILED REPORT

During this reporting period, a quality assurance inspection trip was made to the Paris, Texas shop of Babcock & Wilcox. This trip was made to inspect the fabrication and assembly work of replacement burners for IPP, Unit No. 1.

During the inspection one of the air register assemblies was being moved to the assembly area by overhead crane. Because of a malfunction of the crane the assembly was damaged. The results of the damage were as follows:

- One turn buckle was bent
- One of the outer ring alignment studs was broken.
- * The outer ring was rotated to the limit of its stops.

J. E. Avery 3/13/92 JRH 3/19/92 These conditions were repaired. The assembly was checked by B&W's QA inspector, no other damaged was noted.

During an in-process inspection in the burner assembly area, one of the air zone damper (AZD) plates was noted to be severely warped. The plate was already installed in the burner. The plate was approximately 7/8" out of flatness. Production personnel indicated that this condition could be corrected by heat setting the plate. It was also noted that the spacer tabs mounted on the ID of the AZD assembly, to provide a 1/2" air gap, were off by as much as $\pm 1/8$ ". This condition was also brought to the attention of the production staff and was corrected.

The warped AZD plate was checked by the DWP QA engineer the following day and was found to be within tolerance.

During this visit, two trailers were loaded and ready for shipping, four clockwise and four counter clockwise. On two of the burners the shipping cradles under the air register assemblies were found not to be in full contact with the assemblies. The cradles had to be removed to correct the condition. Following the repair of the cradles, Load Nos. 5 and 6 were released for shipping and Mr. C. Finnigan at IPP was notified.

During the continuing in-process inspection by the DWP QA engineer parts awaiting assembly were checked. While spot checking various parts, additional spacer tabs in the AZD vane assemblies, the same ones mentioned above, were found to be out of tolerance. One of the AZD air sleeves was dimensionally checked and found to be out of round by over 1/2".

All of the above conditions were discussed with Mr. J. Taack, burner production manager, and Mr. J. Langley, burner and pulverizer QA supervisor. The DWP QA engineer expressed concern over the fact that defective parts were finding their way into the assembly area and into the burner assemblies themselves.

Mr. Taack said that he would motivate the assembly crews to be more aware of the parts they are assembling.

Mr. Langley said he would have his inspector increase his in-process inspections.

J. E. Avery 3/13/92

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As far as schedule is concerned, the work is about 1 1/2 weeks ahead. This was expected as additional work is scheduled to start in the shop the week of March 16, 1992, which may impact this contract and use up some of the cushion.

JEA:sl

c: J. Hintze - IPP

- C. Finigen IPP
- D. W. Fowler (Original)
- R. Krikorian
- R. Jaramillo
- J. R. Haynie
- J. E. Avery
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J. E. Avery 3/13/92